IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

Applicant : Ron Grosz et al. Art Unit : 1732
Serial No. : 09/784,493 Examiner : Edmund H. Lee
Filed : February 15, 2001
Title : METHODS OF MANUFACTURING PERSONAL CARE PRODUCTS

Mail Stop Appeal Brief - Patents
Commissioner for Patents
P.O. Box 1450
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BRIEF ON APPEAL

Applicants are appealing the final rejection of claims 1-27, 31, and 32 in the office action dated September 16, 2003. Applicants request that the rejection be reversed. A notice of appeal was filed on December 31, 2003.

I. Real Party in Interest

The real party in interest is The Gillette Company, Prudential Tower Building, Boston, Massachusetts.

II. Related Appeals and Interferences

There are no related appeals or interferences.

III. Status of Claims

Claims 1-5, 8, 12, 15, and 16 stand rejected under 35 U.S.C. § 103(a) over Shelton, U.S. Pat. 4,120,948 ("Shelton I") in view of Piscopo et al., U.S. Pat. 5,984,553 ("Piscopo").

Claims 6 and 7 stand rejected under 35 U.S.C. § 103(a) over Shelton I in view of Piscopo and further in view of Kearney et al., U.S. Pat. 4,366,038 ("Kearney").

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Claims 9 and 17 stand rejected under 35 U.S.C. § 103(a) over Shelton I in view of Piscopo and further in view of Romanco, U.S. Pat. 5,643,467 ("Romanco").

Claims 10 and 11 stand rejected under 35 U.S.C. § 103(a) over Shelton I in view of Piscopo and further in view of Look, U.S. Pat. D454,665 ("Look").

Claims 13, 14, 18, 19, 31 and 32 stand rejected under 35 U.S.C. § 103(a) over Shelton I in view of Piscopo and further in view of Szekely, U.S. Pat. 5,947,621.

Claims 20, 21, and 24-27 stand rejected under 35 U.S.C. § 103(a) over Shelton I in view of Piscopo and further in view of Yarossi et al., U.S. Pat. 4,518,553 ("Yarossi").

Claims 22 and 23 stand rejected under 35 U.S.C. § 103(a) over Shelton I in view of Piscopo and Yarossi and further in view of Pico, U.S. Pat. 3,972,974 ("Pico").

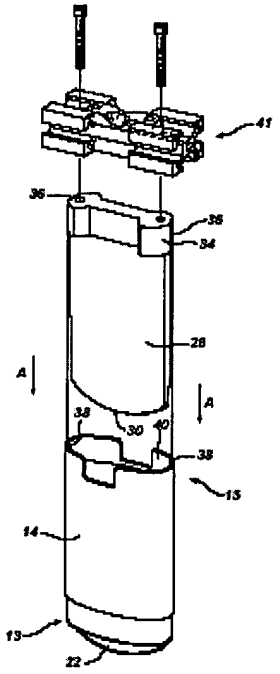
IV. Status of Amendments

Applicants have filed an amendment along with this brief canceling claim 30 to simplify the issues for appeal. Applicants assume this amendment will be entered and reserve the right to pursue claim 30 in a future continuation or divisional application. All other amendments have been entered.

V. Summary of Invention

Claim 1 relates to a method of manufacturing an antiperspirant or deodorant product. Figure 2 in the application illustrates an apparatus used in an embodiment of the method:

FIG. 2



Referring to Figure 2, the product includes a container 14 having an application end 13 and an opposite end 15. A removable insert 28 is inserted into the container through end 15. The container defines part of a mold cavity and a first composition is delivered in fluid form to the mold cavity. After the composition at least partially solidifies, insert 28 is removed to provide a space. A second composition in fluid form is delivered to the space and contacts the first composition after delivery. The first composition and/or the second composition includes an antiperspirant salt and/or a deodorant active ingredient. Claim 1 covers this method and reads as follows:

> 1. A method of manufacturing an antiperspirant or deodorant product within a container having an application end and an opposite end, the product having an application surface adjacent the application end, the method comprising:
>
> (a) delivering a first composition in fluid form through the opposite end of the container to a mold cavity that is defined at least in part by the container, the mold cavity including a removable insert;
>
> (b) allowing the first composition to at least partially solidify;
>
> (c) removing the insert from the mold cavity to provide a space; and
>
> (d) delivering a second composition in fluid form to the space that was occupied by the insert, the second composition contacting the first composition after delivery;

/

wherein at least one of the first and second compositions includes an antiperspirant salt and/or a deodorant active ingredient.

End 15 of container 14 eventually is sealed. Application end 13 includes domed factory seal 22. To use the product, a consumer removes factory seal 22 to expose the application surface of the product. These details are not required by claim 1.

Claim 6 depends from claim 1 and further requires that the insert include a flange that fits securely within the opposite end of the container. An example of this type of flange is illustrated in Figure 2. As discussed on page 5 of the specification, "flange 34 on insert 28 fits snuggly within the opposite end 15."

Claim 7 depends from claim 1 and further requires providing the insert with a taper for ease of removal. An example of a tapered insert is illustrated in Figure 2; insert 28 is tapered.

Applicants will discuss claims 22, 23, 26, and 27 later when addressing the rejections of these claims. Claims 22, 23, 26, and 27 relate to embodiments different from the embodiment illustrated in Figure 2.

VI. Issues

Have the claims been properly rejected under 35 U.S.C. § 103(a) over the combination of references listed in Status of Claims (above)?

VII. Grouping of Claims

Claims 1-5, 8-21, 24, 25, 31, and 32 stand or fall together.

Claim 6 stands or falls separately.

Claim 7 stands or falls separately.

Claims 22 and 23 stand or fall together.

Claims 26 and 27 stand or fall together.

Applicants have made these groupings to simplify the issues on appeal. A particular claim in a group may be patentable for other reasons that do not apply to the entire group. Applicants preserve the right to present further arguments with respect to each claim in subsequent proceedings before the Patent and Trademark Office or in subsequent litigation.

VIII. Argument

A. Shelton I and Piscopo Were Improperly Combined

Shelton I is the culmination of a failed effort by the Proctor & Gamble Co. ("P&G") in the mid-1970's to develop a "two-phase" antiperspirant/deodorant product. The two-phase product consisted of a solid hydrophobic phase including an antiperspirant salt and an alcohol-based gel phase including a deodorant active ingredient. The Examiner summarizes the method used by Shelton I to prepare the two-phase product as follows (see the office action dated September 10, 2003):

> Shelton teaches a method for the manufacturing of an antiperspirant/deodorant product (title) within a container (Column 11, line 12), the method comprising delivering a first composition in fluid form to a mold container the mold container including a removable insert (Column 11, line 18), delivering a second composition in fluid form to the space that was occupied by the insert (Column 11, lines 19-20). It is obvious in the process of Shelton that the second delivered composition contacts the first composition after delivery.

The Examiner also acknowledges that claim 1 is novel in view of Shelton I because, for example, Shelton I does not disclose delivering the first composition through the opposite (non-application surface) end of the container.

Piscopo describes a method of forming a "one-phase" antiperspirant stick in a container that includes an elevator. Piscopo, col. 2, lines 30-67. The method involves using the elevator, which doubles as a "fill pipe", to fill the container with the antiperspirant composition. Id. lines 40-42 and 58-64. Filling can be from the bottom end of the container. The elevator remains in the container even after the filling is completed, and allows the customer to advance the contents of the container. Id. lines 58-67 and col. 3, lines 1-3. The Examiner contends (page 3 of the action dated September 10, 2003):

> It would have been obvious to one having ordinary skill in the art at the time of invention to modify the process of Shelton [I] to directly mold the antiperspirant/deodorant product in a deodorant/antiperspirant disperser-applicator as taught by Piscopo et al. in order form [sic] the antiperspirant/deodorant product in a ready to use state that would not require any further packaging steps before being sold to a consumer.

But in reaching this conclusion, the Examiner failed to acknowledge, or address, the fact that Shelton I's two-phase product was a failure. As a result, a person of ordinary skill in the art would not have been motivated to make the two-phase Shelton I product by any method, let alone the method covered by claim 1.

The unacceptability of the two-phase Shelton I product was discussed in two P&G patents filed after Shelton I. The first of these patents was filed shortly after Shelton I and in it Shelton himself acknowledged that Shelton I provided an unacceptable consumer product. (see Shelton, U.S. Pat. 4,202,879, col. 1, lines 55-58, emphasis added):

> Combinations of a conventional waxy antiperspirant composition with a soap/alcohol gel to form a two-phase stick composition could enhance composition efficacy and improve composition cosmetic benefits. Such combination is, however, not made without certain difficulties. While each phase alone of such a stick composition is stable, contact between the two phases can cause destructive interaction between the two phases. The alcohol/gel phase experiences syneresis which is a bleeding or leaking of the gelled alcohol from the gel structure or matrix. Such leaked alcohol can interact with components of the waxy phase and can thus consume or physically separate the phases, thereby resulting in an unacceptable consumer product.

Applicants will refer to this patent as Shelton II. In Shelton II, Shelton overcame the bleeding problem of Shelton I by adding a third, thin barrier phase between the two phases in the Shelton I product.

The unacceptability of the two-phase Shelton I product was reiterated in another P&G patent filed after Shelton II. That patent, Fryar et al., U.S. Pat. 4,393,643 ("Fryar"), repeated the language quoted above from Shelton II (see Fryar, col. 1, lines 41-54). Once again, Fryar overcame the problem by including a barrier phase between the two phases in the Shelton I product.

The criticism of the two-phase Shelton I product in Shelton II and Fryar is a classic example of "teaching away". As the Federal Circuit discussed in In re Gurley, 31 U.S.P.Q.2d 1130, 1131 (1994):

> A reference may be said to teach away when a person of ordinary skill, upon reading the reference, would be discouraged from following the path set out in the reference, or would be led in a direction divergent from the path that was taken by the applicant.

References that teach away from an invention must be considered in a 35 U.S.C. § 103(a) analysis. As the Federal Circuit explained in Arkie Lures, Inc. v. Gene Larew Tackle Inc., 43 U.S.P.Q.2d 1294, 1297 (1987):

> The evidence that the combination was not viewed as technically feasible must be considered, for conventional wisdom that a combination should not be made is evidence of nonobviousness.

The Examiner erred by not factoring Shelton II and Fryar into his 35 U.S.C. § 103(a) analysis. Shelton II and Fryar both teach that the approach taken in Shelton I provided an unacceptable consumer product. Factoring in Shelton II and Fryar, a person of ordinary skill in the art, to the extent looking to develop a two-phase Shelton I-type product, would also include the barrier phase from Shelton II or Fryar in the product.[1] That person would not be motivated to develop other procedures for making a two-phase Shelton I product based on Piscopo or any other prior art procedure.

The combination of Shelton I with Piscopo is inappropriate for an additional reason. Shelton I describes inserting a removable insert into a container, filling the outside of the removable insert with one phase, removing the insert, and filling the space left by the insert with a second phase. In contrast, Piscopo teaches filling a container with a single phase composition through the elevator. The elevator remains in place in the container throughout the filling process and afterward since it is an integral part of the dispenser. Because Piscopo teaches that the elevator should remain in place, it would not be possible to insert or remove a removable mold insert as described by Shelton. Thus, it is not at all clear how one should combine these two references and, absent some clear direction, the skilled worker would not be motivated to combine them as the Examiner has postulated.

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[1]The barrier phases taught by Shelton II and Fryar are essentially inactive and, as a result, are kept thin. In Shelton II, the barrier phase is formed by dipping a previously formed "core" in molten barrier phase. The "shell" phase later is added in a mold. See Shelton II, col. 17, lines 4-27. In Fryar, the barrier phase is provided as a thin coating on the removable insert used during manufacture of the product. The coating remains behind when the insert is removed to provide space for the second composition. See Fryar, col. 2, lines 59-63, col. 4, lines 32-45, and col. 7, lines 19-36. The methods disclosed by Shelton II and Fryar are substantially different from the method covered by claim 1. The Examiner recognizes this and, in fact, prior to this appeal withdrew a rejection based on Fryar.

The 35 U.S.C. § 103(a) rejection of all the claims on appeal should be reversed for the above reasons.

B. Claim 6

Claim 6 depends from claim 1 and requires that the insert includes "a flange that fits securely within the opposite end of the container." Neither Shelton I nor Piscopo teaches an insert including such a flange. However, the Examiner looked around and uncovered a flange (18 in the Figure below) in the ion-sensitive electrode assembly disclosed by Kearney:

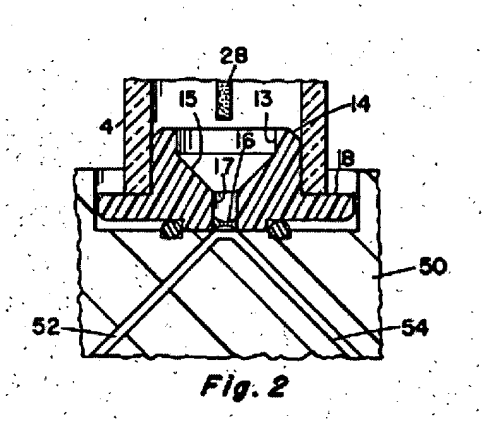

Fig. 2

The structure of the ion-sensitive assembly will not be discussed further, except to note that flange 18 is sealed to the assembly during manufacture using an ultrasonically welded or solvent bond. See Kearney, col. 2, line 64 - col. 3, line 1.

The Examiner contends (page 5 of office action dated September 10, 2003):

> It would have been obvious to one having ordinary skill in the art at the time of the invention to make the insert of Shelton to include a flange as taught by Kearney et al. that would fit securely within the open end of the container (package) in order to ensure the proper placement of the insert within the container.

The Examiner's position is wrong for at least three reasons.

First, Kearney obviously relates to electrode assemblies, a field far removed from antiperspirant and deodorant products. A person of ordinary skill in the art, looking to make an antiperspirant or deodorant product, would not look to electrode assemblies for guidance.

Second, Shelton does not suggest that the "insert core" used in Shelton I fails to fit securely, or even that a secure fit is desirable. The Examiner is reading a problem into Shelton I that does not exist.

Third, claim 6 includes the limitations of claim 1 and requires the removal of the insert after delivery of the first composition. The flange used by Kearney is bonded to the assembly and is not removable. A person of ordinary skill in the art, looking to design a removable "insert core" for use in Shelton I, would not look to non-removable components for guidance.

The Examiner clearly relied on applicants' specification as a roadmap for reconstructing the method covered by claim 6 from the prior art. This is improper. As the Federal Circuit explained in W.L. Gore and Associates v. Garlock, Inc., 220 U.S.P.Q. 303, 312-13 (Fed. Cir. 1983):

> To imbue one of ordinary skill in the art with knowledge of the invention when no prior art reference or references of record convey or suggest that knowledge, is to fall victim to the insidious effect of a hindsight syndrome wherein that which only the inventor taught is used against its teacher.

The 35 U.S.C. § 103(a) rejection of claim 6 should be reversed for these additional reasons.

C. Claim 7

Claim 7 depends from claim 1 and includes "a taper" to allow the insert to be easily removed. Neither Shelton I nor Piscopo teaches an insert including such a taper. The Examiner relies on the electrode assembly from Kearney (see previous illustration) for the taper and reasons (page 5 of office action dated September 10, 2003):

> Kearney et al., however, does include a taper (Figure 1). It would have been obvious to one having ordinary skill in the art at the time of invention to make the insert of Shelton with the structure as taught by Kearney et al. including a taper in order to provide a means of properly placing the insert within the container mold.

This position also is wrong for at least four reasons.

Three of the reasons were already discussed above with respect to claim 6. First, Kearney concerns electrode assemblies, not antiperspirant or deodorant products, and a person of ordinary skill in the art looking to make antiperspirant or deodorant products would not look to Kearney for guidance. Second, Shelton I never suggests a need for some special mechanism for

placing his "insert core" within a container mold. The Examiner is reading a problem into Shelton I that does not exist. Third, claim 7 includes the limitations of claim 1 and requires the removal of the insert after delivery of the first composition. The flange used by Kearney is bonded to the assembly. A person of ordinary skill in the art, looking to design a removable insert core for use in Shelton, would not look to non-removable components for guidance.

Furthermore, claim 7 requires a taper that allows the insert to be easily removed. Only the bottom corner of flange 18 in Kearney is tapered. Even if flange 18 is added to the insert core in Shelton, the small tapered portion at the bottom would not make the insert easily removable from a container because the bulk of the outer surface of the flange still would sit flush against the container. This is not surprising since flange 18 was designed for permanent attachment to the electrode assembly.

The Examiner once again improperly used applicants' specification as a roadmap for reconstructing claim 7 from the prior art. The 35 U.S.C. § 103(a) rejection of claim 7 should be reversed for these additional reasons.

D. Claims 22 and 23

Claim 22 depends from claim 1 through claims 20 and 2. Claim 22 further requires that a first portion of the mold cavity (in claim 1) defines an application surface of the product (see claim 2); that the first portion is defined by a mold member constructed to receive the container in sealing engagement (see claim 20); and that prior to step (a) in claim 1 the insert is inserted through an opening in the mold member (claim 22). The insert subsequently is removed (see step (c) in claim 1) before the second composition is added (step (d) in claim 1). Claim 23 depends from claim 22 and further requires (between steps (c) and (d) in claim 1) sealing the opening with a sealing member that with the mold member defines a dome-shaped surface for the first portion. An embodiment of the process covered by claims 22 and 23 is illustrated in Figures 16-21 and discussed on pages 7 and 8 of the present application.

The Examiner rejected claims 22 and 23 over Shelton, Piscopo, and Yarossi in view of Pico. Yarossi discloses a process for preparing a wax stick product that uses a container with a "pouring cap" that provides an application surface for the stick. The container, which is inverted during some of the manufacturing process, is shown below (Figure 1 from Yarossi):

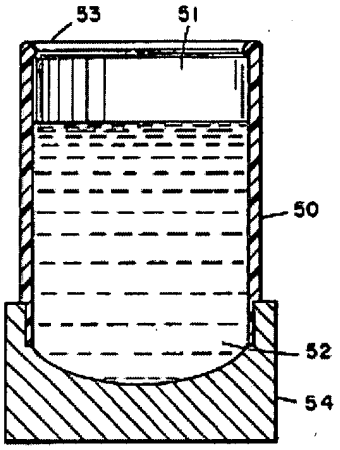

FIG. 1

The "pouring" cap is 54. The container is filled through opening 51 (Yarossi, see col. 2, lines 19-21) and, subsequently, a "twist-up assembly" is applied to opening 51, as shown below (Figure 2 from Yarossi):

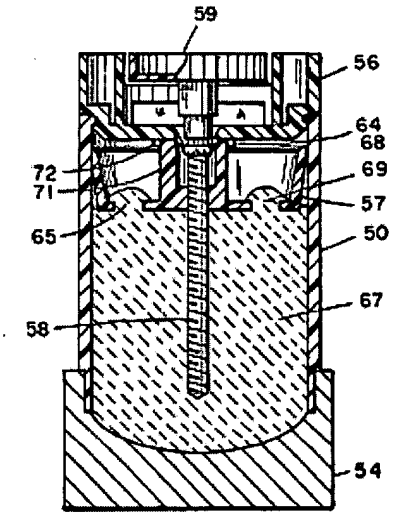

FIG. 2

Pour cap 54 in Yarossi is a mold member that defines an application surface of the product and receives the container (50 in Figures 1 and 2) in sealing engagement. However, Yarossi does not suggest that the pour cap should, or could, include an opening through which an insert can be added prior to filling the container through opening 51. In an effort to fill this

rather large gap, the Examiner came up with Pico, a reference that relates to making the abrasion-resistant screening apparatus shown below (Figure 4 of Pico):

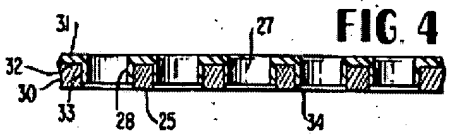

FIG. 4

The screening apparatus includes a substrate 30 having perforations 27 and abrasion-resistant coating 31.

Figures 6 and 7 of Pico provide some details of the method used to make the screening apparatus:

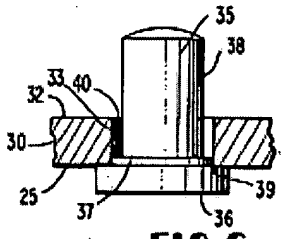

FIG. 6

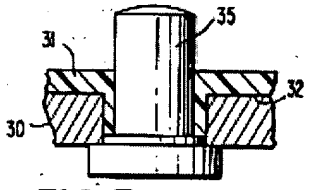

FIG. 7

The method includes inserting plugs 35 through perforations 27, applying coating 31, and removing the plugs. According to the Examiner (pages 11-12 of the office action dated September 10, 2003):

> With regard to claims 22 and 23, Shelton does not specifically teach how the insert is placed into the mold container. Pico, however, teaches a way to insert an insert into a mold body in order to leave a passage through the molded body by having an insert that goes through and seals a hole in the bottom of a mold part (Figures 6 and 7). It would have been obvious to one having ordinary skill in the art at the time of invention to modify the process of Shelton to include the use of an insert that is inserted through the bottom of the mold part in order to ensure that none of the first formed material leaks into the area for the second material causing an inferior product.

This is another hindsight rationale. Abrasion-resistant screening apparatuses have no connection with antiperspirant or deodorant products. Abrasion-resistant screening apparatuses are not applied to the skin and, in fact, do not include anything remotely capable of rubbing off on the skin. A person of ordinary skill in the art, looking to make an antiperspirant or deodorant product, would not look to Pico for guidance.

Furthermore, Pico teaches coating a screen with one coat, whereas Shelton I discusses molding a two-phase deodorant/antiperspirant product. Pico does not apply another composition to fill in the perforation after the plugs are removed; filling in the perforation would destroy the screening apparatus. In contrast, Shelton I fills the gap left after removal of the insert core with a second composition.

Finally, Shelton I inserts the "insert core" through the top of the container. A person of ordinary skill in the art would have no reason to look to replace the "insert core" approach with an insert that is inserted through a mold member on the bottom of the container. Indeed, that person would have avoided such an approach out of concern for potential leakage between the insert and the mold member.

Applicants request that the 35 U.S.C. § 103(a) rejection of claims 22 and 23 should be reversed for these additional reasons.

E. Claims 26 and 27

Claim 26 depends from claim 1 through claims 20 and 2. Claim 26 further requires that a first portion of the mold cavity (in claim 1) defines an application surface of the product (see claim 2); that the portion is defined by a mold member constructed to receive the container in sealing engagement (see claim 20); and that the insert (in claim 1) extends from and is integral with the mold member (claim 26). The mold member/insert subsequently is removed (see step (c) in claim 1) before the second composition is added (step (d) in claim 1). Claim 27 depends from claim 26 and further requires applying a factory seal to the application surface between steps (c) and (d) in claim 1. An embodiment of this process is illustrated in Figures 22-25 and described on page 9 of the application.

The Examiner rejected claims 26 and 27 over Shelton and Piscopo in view of Yarossi. These references were discussed above. According to the Examiner (page 11 of the office action dated September 10, 2003):

> With regard to claims 26 and 27, it is well know in the art of molding to have integral mold parts (mold parts with attached projections). It would have been obvious to connect the insert part of the bottom part of the mold in order to create an automatic correct placement of the insert in the mold container without the possibility of leaks of material unwanted areas in the process of Shelton in view of Yarossi et al. It [sic] such a case it would have been further obvious to one having ordinary skill in the art at the time of invention to remove the mold part after the solidification of the first composition and to place the factory seal of Piscopo et al. for the molding of the second composition in order to ensure the second composition stays in the container.

In providing this rationale, the Examiner admits that Shelton, Piscopo, and Yarossi do not disclose using a mold member with an integral insert that is applied to the application end of the container when performing the method of claim 1.[2] Instead, the Examiner refers to "integral mold parts" that are "well known in the art of molding", without providing with any specific prior art disclosing such integral mold parts. Of course, Shelton I, Piscopo, and Yarossi generally do not suggest using such an integral mold member/insert in a method covered by claims 26 and 27. Shelton I discloses an "insert core" that is inserted into the non-application end of the container. But Shelton I does not suggest modifying his process to make the "insert core" part of an integral mold member/insert assembly that can be applied to the application end of the container.

Beyond this, applicants do not know how to address the rejection because the Examiner has not provided applicants with the "well known" integral mold parts that form the basis for the rejection. The Examiner's failure to provide the prior art that he is relying on is improper. In fact, the Examiner's use of "well known" but unidentified prior art is reminiscent of an Examiner's "phantom prior art" criticized in Ex parte Stern, 13 U.S.P.Q.2d 1379, 1381 (Bd. App. 1989):

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[2]The twist-up assembly described by Yarossi includes spindle 58 (see Figure 2 from Yarossi). But that spindle is part of the final product and is not a mold insert that is removed during the manufacture to provide a space for a second composition. Indeed, spindle 58 is not even in the container when the composition is delivered; it is pressed in through the composition later. Moreover, the twist-up assembly is not inserted into the composition through the application end of the container.

> The Examiner has failed to articulate any recognizable theory to support the rejection of the appealed claim under 35 U.S.C. § 103 as unpatentable over any of these references... [T]he Examiner states on page 4 of the Answer that
>
> > 'Although the prior art fails to recite a protein having such a high specific activity, such is deemed obvious relative to advances in technology that evolves [sic, evolve] more sophisticated purification processes that produces [sic, produce] such high degree of purity.' (Emphasis supplied by Board.)
>
> The Examiner should be aware that "deeming" does not discharge him from the burden of providing the requisite factual basis and establishing the requisite motivation to support a conclusion of obviousness....The Examiner's reference to unidentified phantom prior art techniques falls far short of the mark.

As noted in Ex parte Stern, Examiners have an obligation to provide the basis when making a 35 U.S.C. § 103(a) rejection. The Examiner has fallen far short of that obligation here.

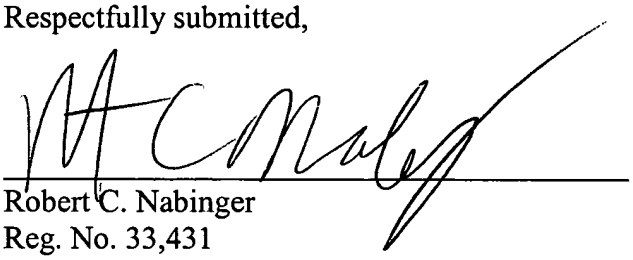
Applicants request that the 35 U.S.C. § 103(a) rejection of claims 26 and 27 be reversed for these additional reasons.

IX. Conclusion

For the above reasons, applicants respectfully request that the 35 U.S.C. § 103(a) rejection of claims 1-27, 31, and 32 be reversed.

The brief fee of $330 is enclosed. Please apply any other charges or credits to Deposit Account No. 06-1050.

Respectfully submitted,



Date: May 5, 2004

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Appendix of Claims

1. A method of manufacturing an antiperspirant or deodorant product within a container having an application end and an opposite end, the product having an application surface adjacent the application end, the method comprising:

(a) delivering a first composition in fluid form through the opposite end of the container to a mold cavity that is defined at least in part by the container, the mold cavity including a removable insert;

(b) allowing the first composition to at least partially solidify;

(c) removing the insert from the mold cavity to provide a space; and

(d) delivering a second composition in fluid form to the space that was occupied by the insert, the second composition contacting the first composition after delivery;

wherein at least one of the first and second compositions includes an antiperspirant salt and/or a deodorant active ingredient.

2. The method of claim 1 wherein a first portion of the mold cavity defines an application surface of the product.

3. The method of claim 2 wherein the first portion is generally dome-shaped.

4. The method of claim 1 further comprising inserting the insert into the container prior to step (a).

5. The method of claim 2 wherein the first portion of the mold cavity comprises a factory seal portion of the container.

6. The method of claim 1 further comprising providing the insert with a flange that fits securely within the opposite end of the container.

7. The method of claim 1 further comprising providing the insert with a taper to allow it to be easily removed.

8. The method of claim 1 further comprising applying downward pressure to the insert during delivery of the first composition.

9. The method of claim 8 further comprising providing the insert with a pressure ridge to sealingly engage an inner surface of the mold cavity.

10. The method of claim 1 wherein the first composition and second composition are different colors.

11. The method of claim 10 wherein the second composition defines a stripe extending through the first composition, when the application surface of the antiperspirant product is viewed from above.

12. The method of claim 1 further comprising (e) allowing the second composition to at least partially solidify.

13. The method of claim 12 further comprising (f) applying a package base to close the opposite end of the container before or after the second composition has at least partially solidified.

14. The method of claim 13 wherein the package base includes an advancement device constructed to advance the antiperspirant product out of the container.

15. A method of manufacturing an antiperspirant or deodorant product having a generally dome-shaped application surface, the method comprising:

(a) delivering a first composition in fluid form to an open end of a mold cavity, a first portion of the mold cavity defining the dome-shaped application surface, the mold cavity including a removable insert,

(b) allowing the first composition to at least partially solidify;

(c) removing the insert from the mold cavity to provide a space; and

(d) delivering a second composition in fluid form to the space that was occupied by the insert, the second composition contacting the first composition after delivery;

wherein at least one of the first and second compositions includes an antiperspirant salt and/or a deodorant active ingredient.

16. The method of claim 15 wherein the insert includes a curved surface shaped to engage the dome-shaped first portion, and the method further comprises inserting the insert into the container, through the open end thereof, until the curved surface sealingly contacts the dome-shaped surface of the first portion.

17. The method of claim 16 further comprising providing the insert with a pressure ridge to sealingly engage an inner surface of the mold cavity.

18. The method of claim 16 wherein the first composition and second composition are different colors.

19. The method of claim 18 wherein the second composition defines a stripe extending through the first composition, when the application surface of the antiperspirant product is viewed from above.

20. The method of claim 2 wherein the first portion is defined by a mold member constructed to receive the container in sealing engagement.

21. The method of claim 20 wherein the method further comprises mounting the application end on the mold member prior to step (a).

22. The method of claim 20 further comprising, prior to step (a), inserting the insert into the mold cavity through an opening in the mold member, the opening being constructed to be sealed by the insert.

23. The method of claim 22 further comprising, between steps (c) and (d), sealing the opening with a sealing member having a surface constructed to, with the mold member, define the dome-shaped surface of the first portion.

24. The method of claim 20 further comprising, after step (d), (e) allowing the second composition to at least partially solidify, and (f) removing the container from the mold member.

25. The method of claim 24 further comprising, after step (f), (g) applying a factory seal to the application surface of the antiperspirant product.

26. The method of claim 20 wherein the insert extends from and is integral with the mold member.

27. The method of claim 26, further comprising, between steps (c) and (d), applying a factory seal to the application surface of the antiperspirant product.

31. The method of claim 1 wherein the insert comprises a material selected from the group consisting of metals, coated metals, plastics and silicone-coated plastics.

32. The method of claim 1 wherein the insert comprises a coated metal selected from the group consisting of stainless steel coated with titanium nitride, chromium, or electroless nickel with or without a polytetrafluoroethylene (PTFE) infusion; aluminum coated with aluminum oxide hardcoat anodizing, hardcoat anodizing with a PTFE infusion, or electroless nickel with or without a PTFE infusion; or aluminum plated with nickel or chrome.